

Date: Friday, 10/5/2007 11:02:10 AM
User: Kim Johnston

Process Sheet

| | |
|--|------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : STRUT |
| Job Number : 35045 | |
| Estimate Number : 10950 | |
| P.O. Number : <i>N/A</i> | Part Number : D2562005 |
| This Issue : 10/5/2007 S.O. No. : <i>N/A</i> | Drawing Number : D2562 REV D |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : <i>MA</i> | Drawing Revision : D |
| Previous Run : 32575 | Material : <i>N/A</i> |
| Written By : <i>[Signature]</i> | Due Date : 10/19/2007 |
| Checked & Approved By : <i>[Signature]</i> | Qty: 10 Um: Each |
| Comment : Est A 02.06.07 New Issue NG | |

Additional Product

Job Number:



| | | |
|---------|-------------------------|---------------|
| Seq. #: | Machining Or Operation: | Description : |
|---------|-------------------------|---------------|

| | | |
|-----|----------------|--------------------------|
| 1.0 | M304TR0500W035 | 304 RD Tube .500 x .035W |
|-----|----------------|--------------------------|



Comment: Qty.: 2.5374 f(s)/Unit Total : 25.3743 f(s)
304/316/318-2B Seamless Tubing, 1/2" O.D. x 0.035" wall
Batch *M 105 575 (7)* *M 104 862 (3)* *SB 07/10/16 (10)*

| | | |
|-----|----------|----------|
| 2.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: NC BRAKE

Punch to length as per Dwg D2562

SB 07/10/16 (10)

| | | |
|-----|-------------|-------------------------------|
| 3.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL/MED FAB RESOURCE

1- Bend end as per Dwg D2562 Angle "D"
2- Deburr

[Signature] *07/10/17* *PTO (9)*

| | | |
|-----|-----|------------------------------|
| 4.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|



Comment: INSPECT WORK TO CURRENT STEP

5 07/10/17 (42) center

| | | |
|-----|----------------|----------------|
| 5.0 | POWDER COATING | POWDER COATING |
|-----|----------------|----------------|



Comment: POWDER COATING

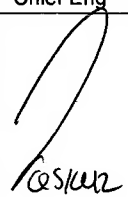



Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M 105 068 *(9X)* *m-l 07/10/18*

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|---------------------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 07/10/17 | 3 | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 07/10/17
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|----------|------|--|--|---------------------------------|----------------|---|--|---|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 07/10/17 | 3 | 1 piece hole was damage in the punch operation RE: opener error |  Koslar | Scrap + destroy no Replace | SP 07/10/17 |  07/10/17 |  Koslar |  07/10/17 |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 10/5/2007 11:02:10 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 35045

Part Number: D2562005

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

8/7/10/18 (9)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *57264*

8/7/10/18 (9)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

8/7/10/18 (9)

Job Completion



IN 8/10/18

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

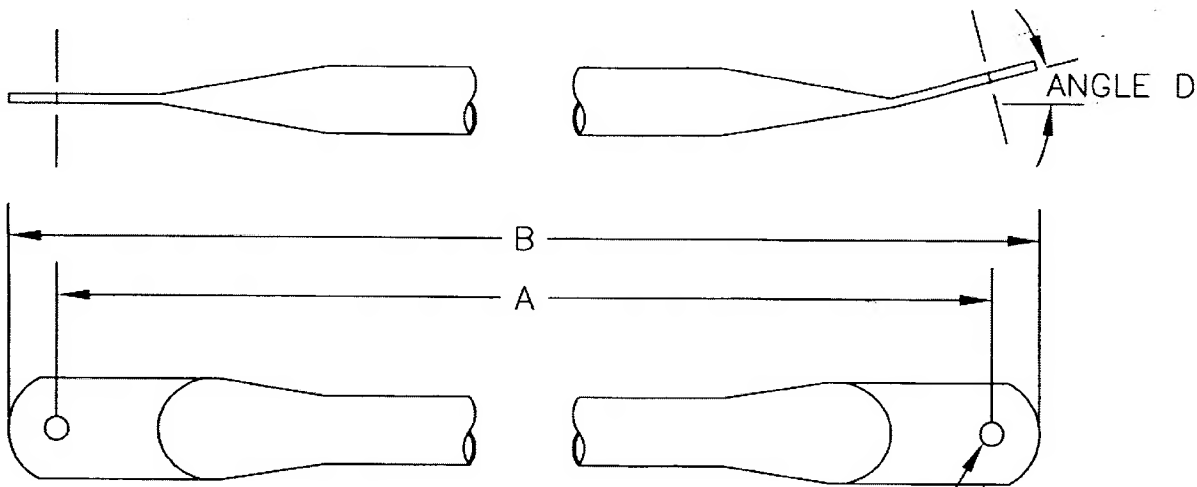
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

DART

| | | | | |
|---------|--------------------|----------------------------------|--------------------|-----------------------------|
| DESIGN | CP | DRAWN BY | RF | DART AEROSPACE LTD |
| CHECKED | <i>[Signature]</i> | APPROVED | <i>[Signature]</i> | HAWKESBURY, ONTARIO, CANADA |
| DATE | 05.05.18 | DRAWING NO. | D2562 | REV. D |
| | | TITLE | STRUT | SHEET 1 OF 1 |
| | | | | SCALE 1:2 |
| A | 96.05.01 | NEW ISSUE | | |
| B | 98.10.15 | UPDATED MATERIAL NOTE (TSR A603) | | |
| C | 02.06.05 | ADD -005; ADD FINISH | | |
| D | 05.05.18 | ADD -007/-011/-013; UPDATE -005 | | |



"C" DIA TO BE OPENED MANUALLY
PUNCH ENDS PER SPEC CONTROL DRAWING D2727

| PART # | DIM A | DIM B | DIA C | ANG D |
|-----------|-------|-------|-------|-------|
| D2562-001 | 19.68 | 20.48 | - | 10 |
| D2562-003 | 20.37 | 21.17 | - | 18 |
| D2562-005 | 29.00 | 29.80 | - | 30 |
| D2562-007 | 19.22 | 20.02 | - | 0 |
| D2562-011 | 25.79 | 26.59 | - | 16 |
| D2562-013 | 26.63 | 27.43 | - | 24 |
| | | | | |
| | | | | |
| | | | | |
| | | | | |

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35045

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.500 OD X 0.035 WALL (REF DART SPEC. M304TR0.500W.035) ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

05.05.27

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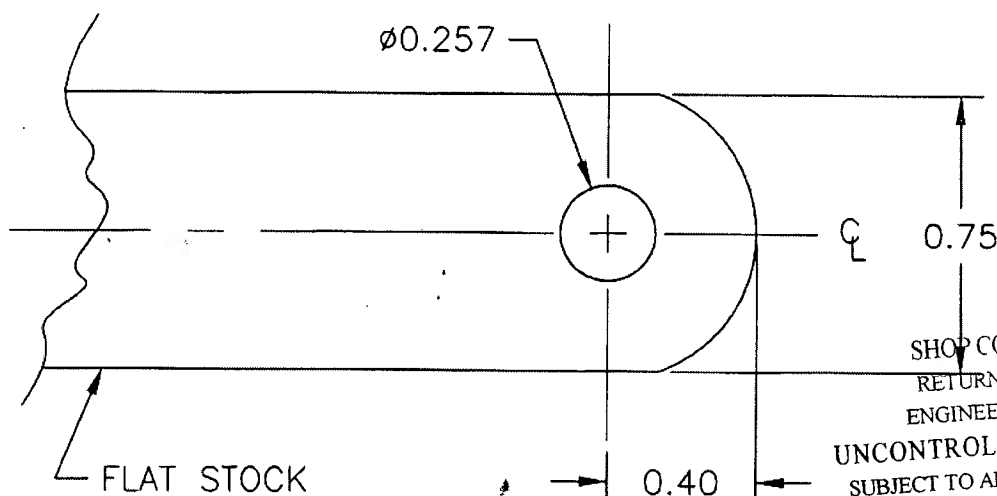
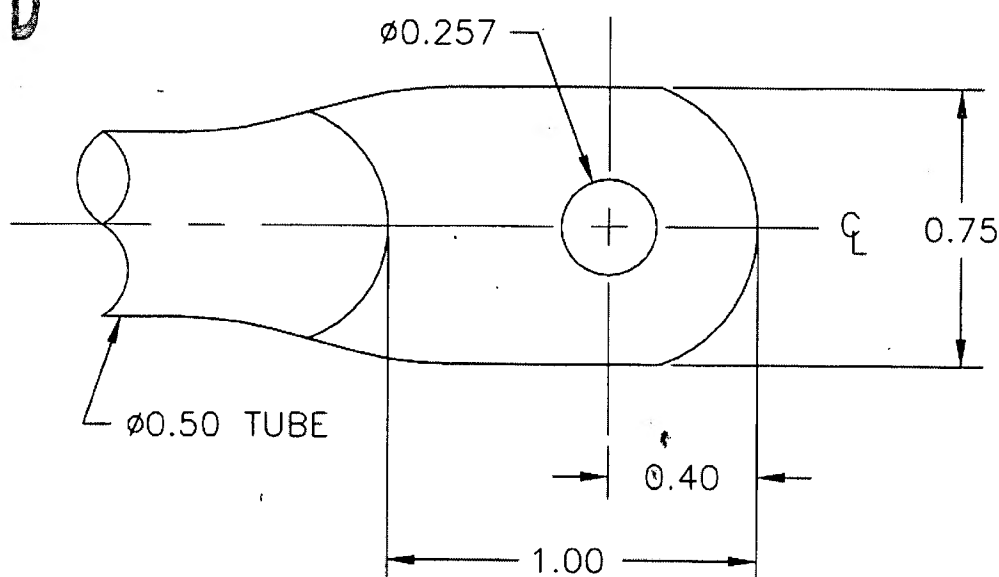
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| | | | |
|----------------------|------------------------------------|--|------------------------|
| DESIGN <i>KE</i> | DRAWN BY <i>KE</i> | DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA | |
| CHECKED <i>my</i> | APPROVED <i>CA</i> | DRAWING NO. D2727 | REV. A SHEET 1 OF 1 |
| DATE 97.11.24 | TITLE PUNCH DT8012 SPEC CONTROL | | SCALE 2:1 |
| A | 97.11.24 | NEW ISSUE | |
| A1 | #CP 01.12.20 | ADD TOLERANCE NOTE | |

SPECIFICATION CONTROL DRAWING FOR PUNCH DT8012

RELEASED
98/03/06 KE



NOTE: TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.



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RETURN TO
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WORK ORDER
NO. 35045

DART Aerospace Ltd

CUSTOMER RETURN

#R08-51

Initiator: Jean Kerr
 Company: Rotocraft Support
 Phone No: 818-997-7667

Date: May 9/08
 Invoice # 16386
 Order Entry # 5931

Reason for return: too long. purchased the incorrect strut.
 Attach Copy of DHS Return Authorization # 414

Receiving: 8/0/06
 Date Received: 8/0/06 Freight Company: FIDEX Prepaid ☐ Collect ☐

| # | Part # | Batch # | Description | Distribute to QC | |
|---|-----------|---------|-------------|------------------|-------------|
| | | | | Advise QA | Date: |
| 1 | D2562-005 | 35045 | Strut | <u>DATE</u> | <u>5/20</u> |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |
| | | | | | |

Condition of packaging: Good Photograph required: yes ☐ no ☒

Paperwork attached: P/S ☒ Invoice ☐ ARC ☐ Docs ☐ Other ☒

QC: Quarantine: Location: Condition of Part: good
 Inspect: Initial:

| # | Part # | Batch # | QC Comments | QC Approval | | Scrap |
|---|-----------|---------|-------------------------|-------------|--------------|-------|
| | | | | Initial | W/O # | |
| 1 | D2562-005 | 35045 | return to stock per W/O | <u> </u> | <u>39500</u> | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |
| | | | | | | |

QA Coordinator: Advise GM as to findings: Initial: Date:

Comments:

| | |
|--|--|
| Issue credit: <input type="checkbox"/> yes <input type="checkbox"/> no | Invoice Amount: <u> </u> |
| GM Approval: <u> </u> | Less Replacement: <u> </u> |
| Date: <u> </u> | Restock Fee: <u> </u> |
| | Freight: <u> </u> |
| | Net Credit: <u> </u> |
| | DHS <input type="checkbox"/> Customer <input type="checkbox"/> |

QA: Enter into Q-Pulse with reason for return & File original. Signed: Date:

Copy of Customer Return to stay with work orders and another copy to be filed with customer credit